

Date: Tuesday, 27/01/2009 11:09:34 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 45245	
Estimate Number : 10613	
P.O. Number :	Part Number : D265615
This Issue : 27/01/2009 S.O. No. :	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 27/01/2009 Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 43991	Material :
Written By :	Due Date : 20/02/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 080127</u>	
Comment : Est: D 02.10.25 Re-format KJ Est Rev:E Now on Waterjet 06-09-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M1010S20GA	1010/1025 SHEET
-----	------------	-----------------



Comment: Qty.: 0.6431 sf(s)/Unit Total : 6.4313 sf(s)
 1010/1025/A21/6aA SHEET (.040")
 (M1010S20GA)
 Batch: 110368 B9-34

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: P
 Prog Rev: D

B9-34

(13)

2-Deburr if necessary B9-34

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK50263/05 (13)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326.
 2-Form joggle as per Dwg D2656 using Jig DT8158
 3-Identify as D2656-15

50263/05 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:09:34 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 45245

Part Number: D265615

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/03/05 (43)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1:00

OVEN TEMPERATURE: 220°

FINISH TIME: 1:30

RF 09-03-06 (B)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 09/03/06 (13X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

MO/M-L 09/03/06 (X13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/06

Job Completion



MF 09-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: H15245
Description: Wearshoe		Part Number: D2656-15
Inspection Dwg: D2656	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.150	+/-0.010	39.150	✓			
35.650	+/-0.010	35.650	✓			
33.650	+/-0.010	33.650	✓			
30.150	+/-0.010	30.150	✓			
24.900	+/-0.010	24.900	✓			
19.650	+/-0.010	19.650	✓			
14.400	+/-0.010	14.400	✓			
9.150	+/-0.010	9.150	✓			
5.650	+/-0.010	5.653	✓			
2.000	+/-0.010	1.999	✓			
1.885	+/-0.010	1.889	✓			
0.300	+/-0.010	305	✓			
0.300	+/-0.010	304	✓			
0.040	+/-0.010	1038	✓			

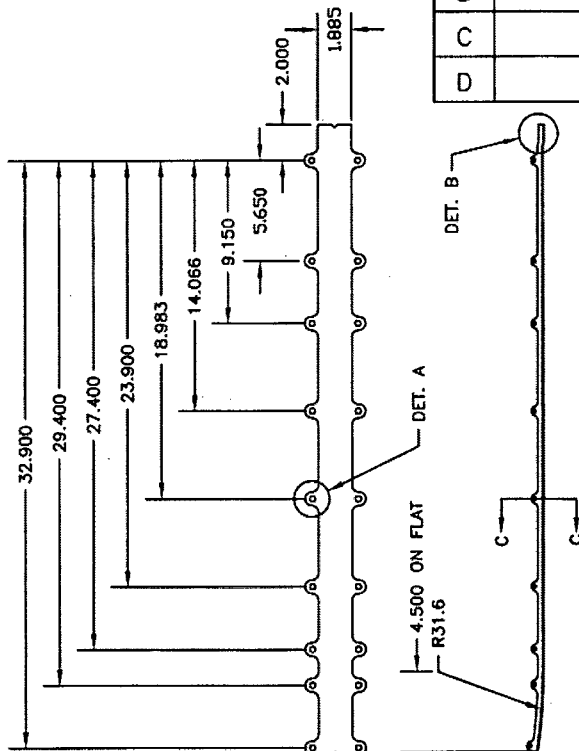
Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-3-4	Date: 09/03/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	B

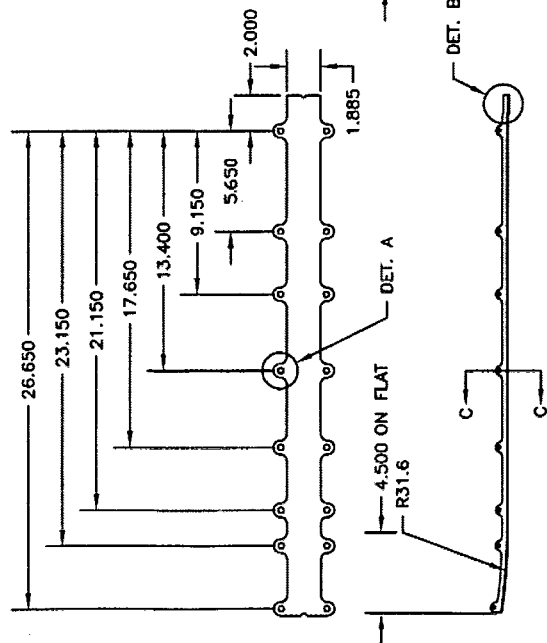


DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2656
				REV. D SHEET 1 OF 4
DATE	05.08.17	TITLE	WEARSHOE	SCALE 1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

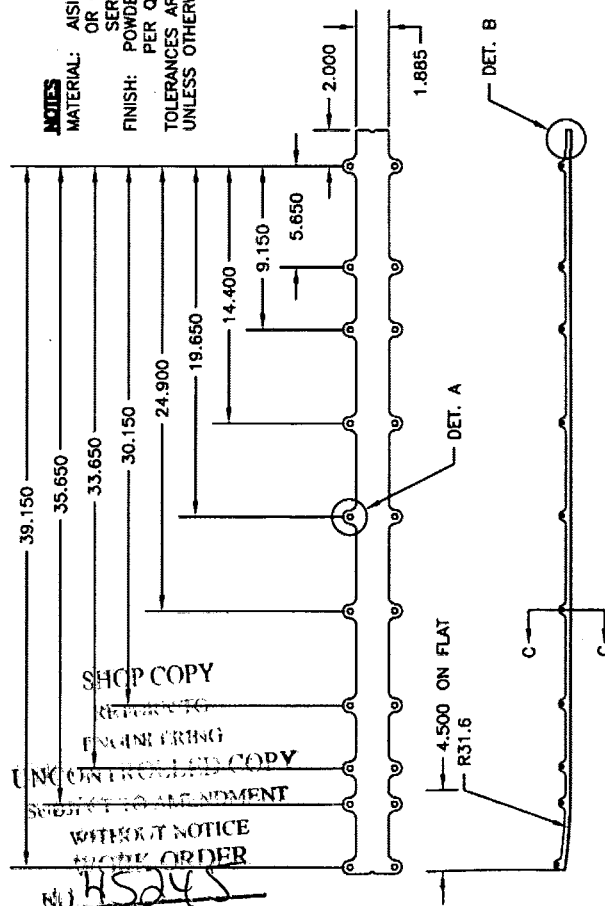
D2656-13



D2656-11



D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05-09-08

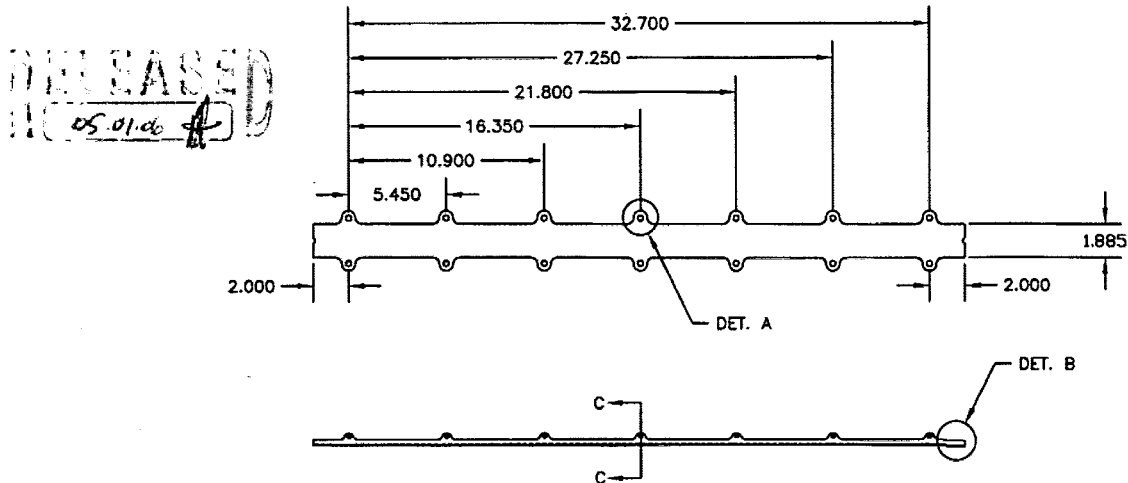
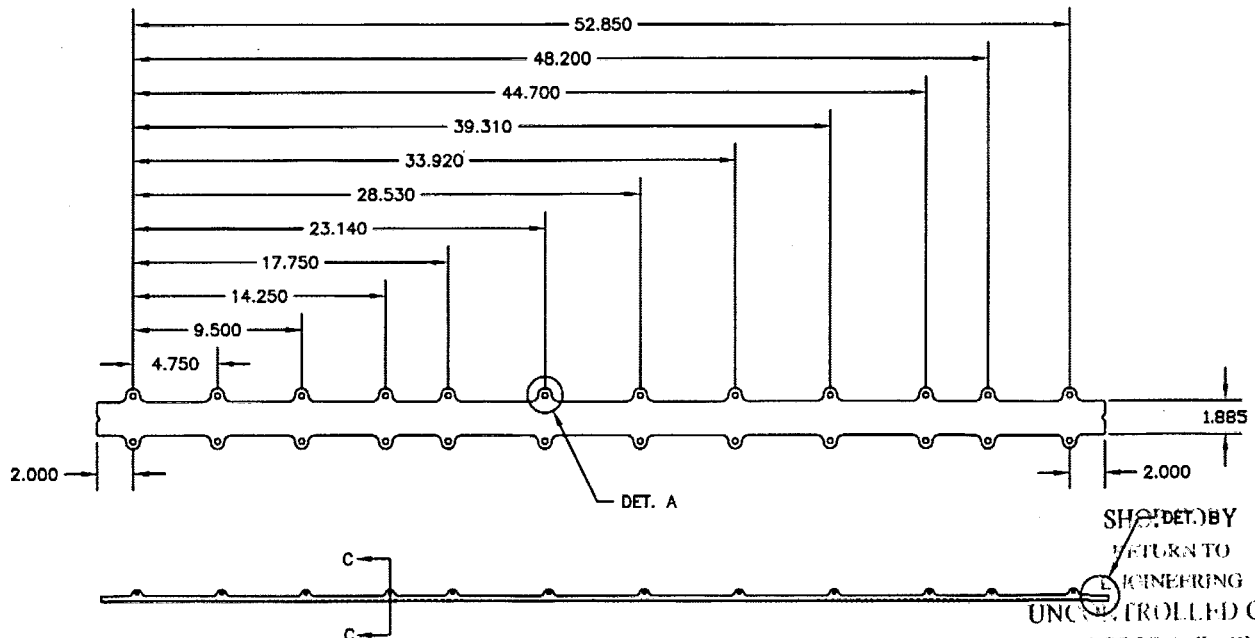
SHOP COPY
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ORDER
NO. 15245

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART

DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 2 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

D2656-21**D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

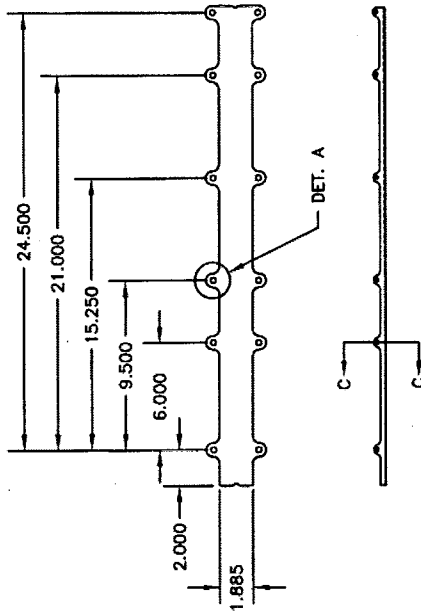
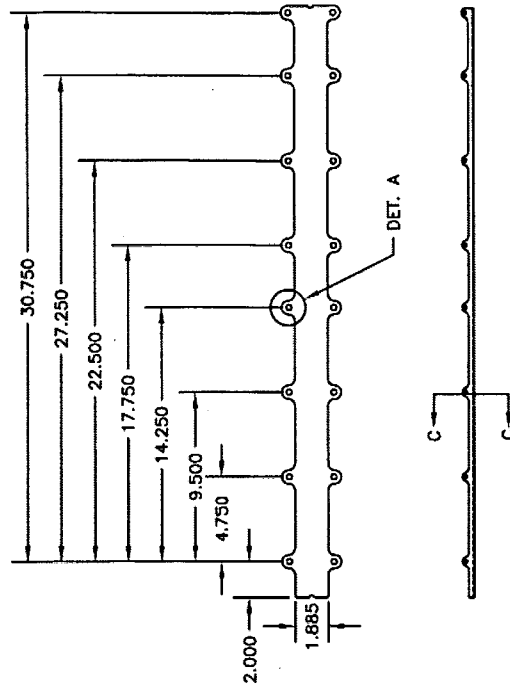
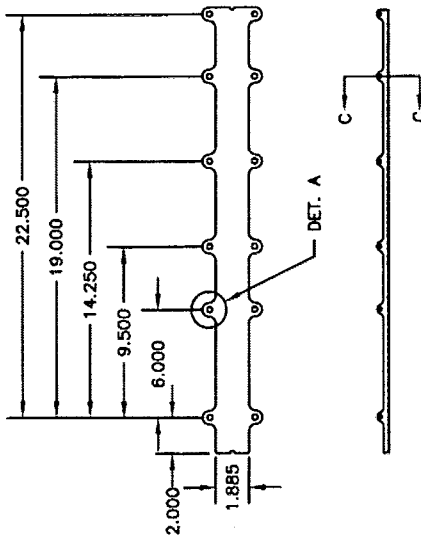
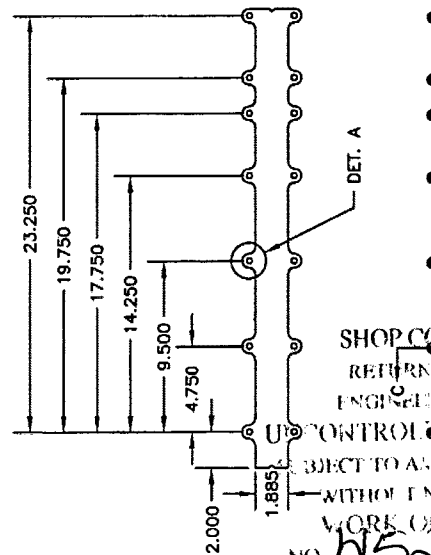
SHOWN BY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45245

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART

DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 3 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33**D2656-37****D2656-31****D2656-35**SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDER

NO. 45245

NOTES
MATERIAL: ANSI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W
SERIES STEEL 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANITEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

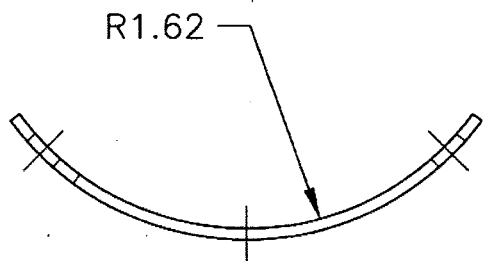
Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

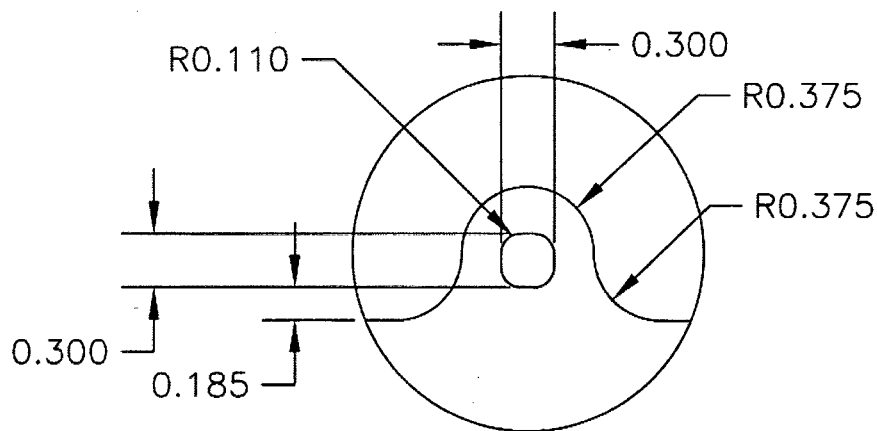


DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

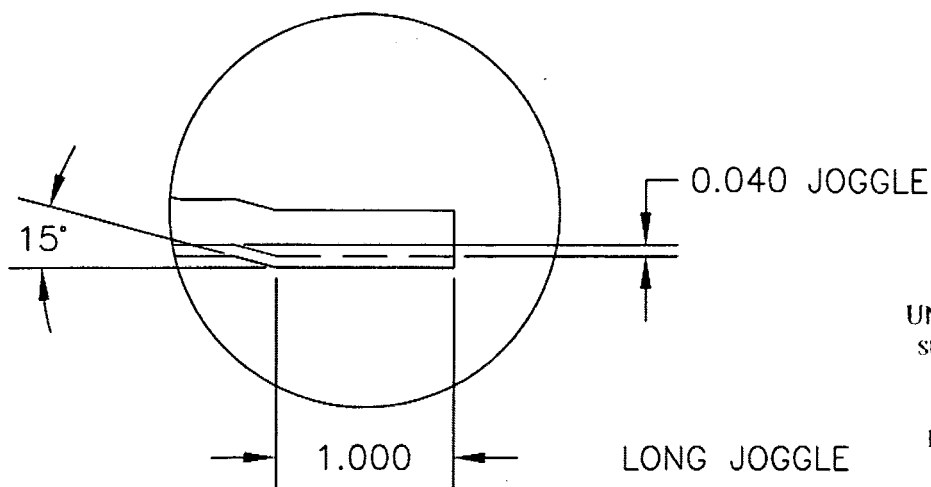
SECTION C-C



DETAIL A



DETAIL B



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45245

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.